

Date: Monday, 6/5/2006 7:48:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 27383	
Estimate Number : 10281	
P.O. Number : <i>N/A</i>	Part Number : D3183043
This Issue : 6/5/2006 S.O. No. :	Drawing Number : D3183 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C1
Previous Run : 26040	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/30/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i> 06.06.05	
Comment : Est Rev: Pick A 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2000X01500	17-4 SS Bar
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Comment: Qty.: 0.4812 f(s)/Unit Total : 1.9249 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.500x02.000)
 Identify for D3183-043
 Batch: *M101422*

*J.F. 06/07/11**4*

2.0	-BAND SAW	BAND SAW
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Comment: BAND SAW *1.500*
 Cut blanks: (*1.500* x 2.000") 5.500" long

*J.F. 06/07/11**4*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3183-3 as per Folio FA322 and Dwg D3183
 Identify as D3183-3

2-Deburr

3-Scribe batch number

31 06/07/17


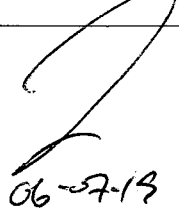
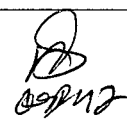
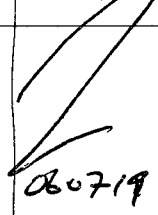
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. 06/07/19**4**4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/18	3	- 1 part scrapped - drill broke in hole		- scrap + replace	J.L 06/07/19	 06-07-19		 06-07-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:48:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27383

Part Number: D3183043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EP 06/09/19

4

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt B26242 * 8

EP 06/09/22

7.0

D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3183-045 Bearing Ass

B25562 * 7 B28653 * 1

EP 06/09/22

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-043 as per Dwg D3183.

EP 06/09/22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 06/09/22

4

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51412

RB 06/09/25 (4)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RB 06/09/25 RB (4)

Job Completion



u 06-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/19								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27383
Description: Bracket		Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	5.190	✓			
R0.063	+/-0.010	1.063	✓			
0.182	+/-0.010	1.183	✓			
0.070	+/-0.010	0.071	✓			
0.100	+/-0.010	0.099	✓			
Ø0.201 x 0.100	+/-0.010	201 X .100	✓			
0.182	+/-0.010	1.183	✓			
5.32	+/-0.030	5.318	✓			
5.036	+/-0.010	5.035	✓			
2.120	+/-0.010	2.120	✓			
1.290	+/-0.010	1.290	✓			
0.365	+/-0.010	0.365	✓			
0.218	+/-0.010	0.216	✓			
1.030	+/-0.010	1.030	✓			
1.90	+/-0.030	1.900	✓			
1.012	+/-0.010	1.012	✓			
Ø0.201 x 0.100	+/-0.010	202 X .100	✓			
0.182	+/-0.010					CANNOT FIND DIM.
0.786	+/-0.010	0.786	✓			
Ø0.392	+0.002/-0.000	0.392	✓			
R0.19	+/-0.030	1.190	✓			
3.954	+/-0.010	3.953	✓			
0.162	+/-0.010	0.164	✓			
R0.19	+/-0.030	1.190	✓			
R0.25	+/-0.030	1.25	✓			
4.26	+/-0.030	4.263	✓			
2.080	+/-0.030	2.110	✓			
1.155	+/-0.010	1.155	✓			
0.162	+/-0.010	0.159	✓			
0.36	+/-0.030	0.360	✓			
0.615	+/-0.010	0.614	✓			
0.435	+/-0.010	0.436	✓			
0.200	+/-0.010	0.203	✓			
0.381	+/-0.010	0.383	✓			
0.032	+/-0.010	0.033	✓			

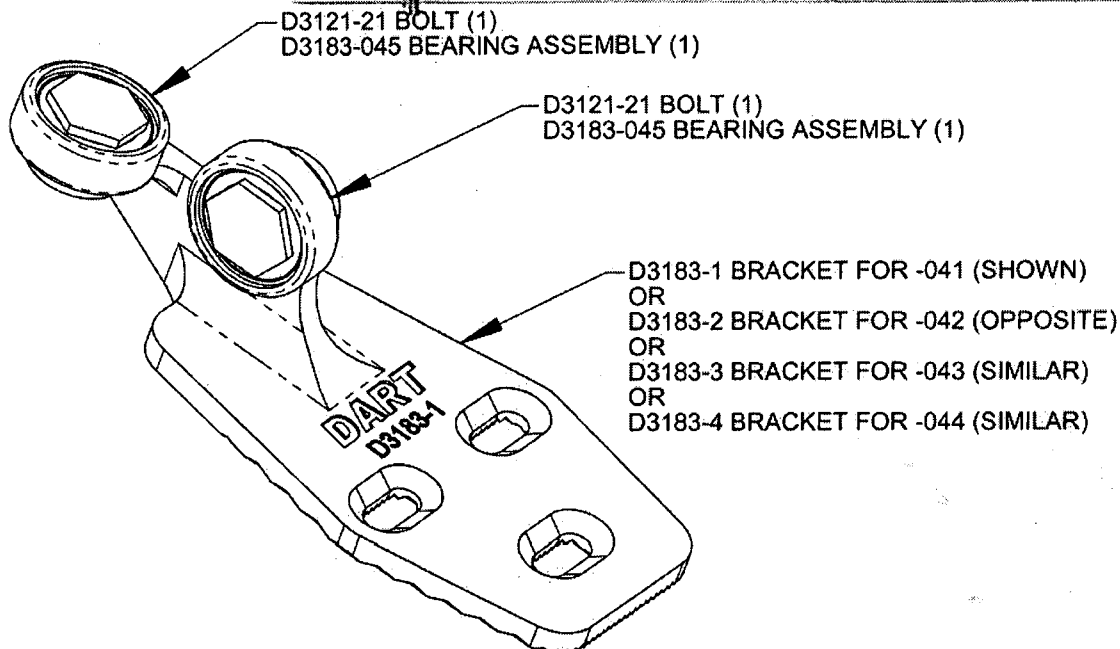
Measured by:	31	Audited by:	En	Prototype Approval:	N/A
Date:	06/07/18	Date:	06/07/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	

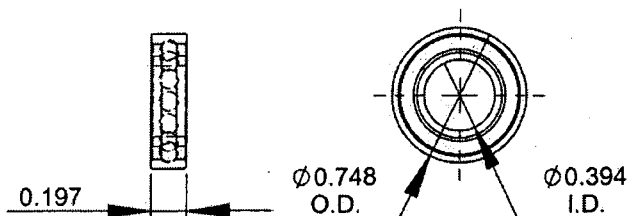


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CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

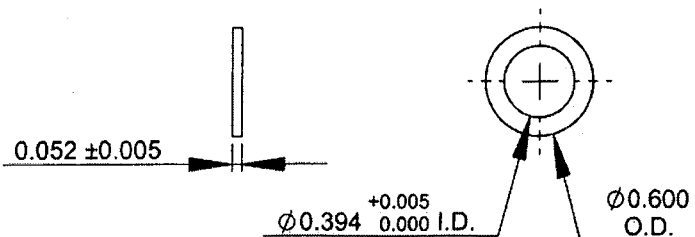


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R)DPY ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSF 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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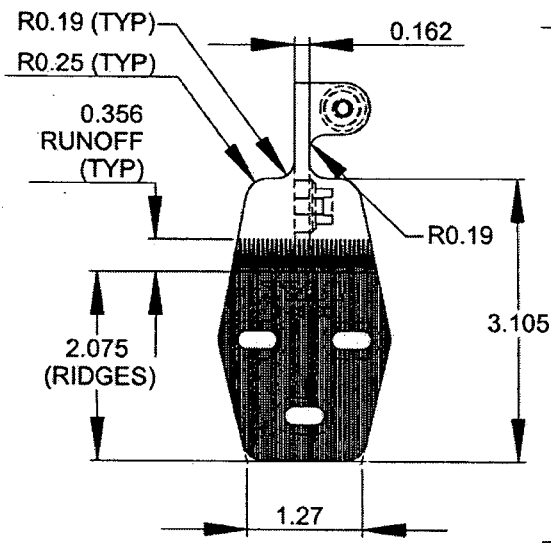
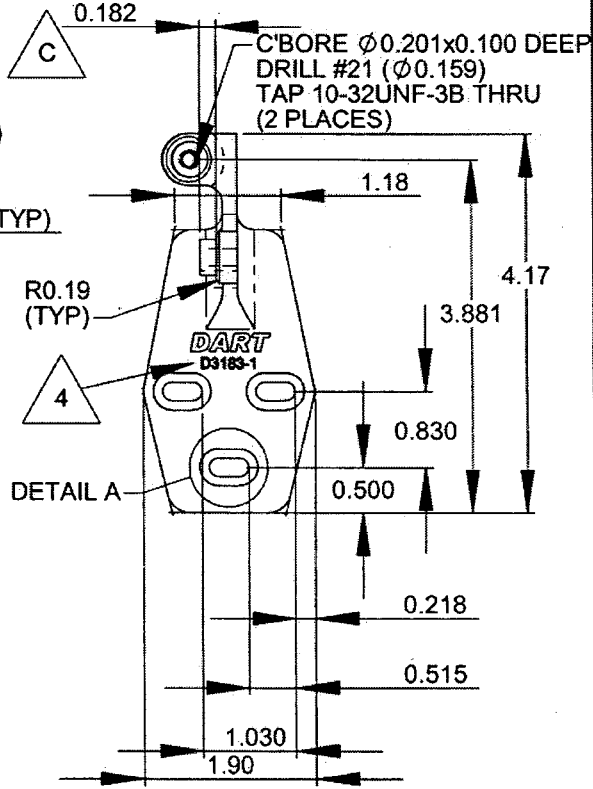
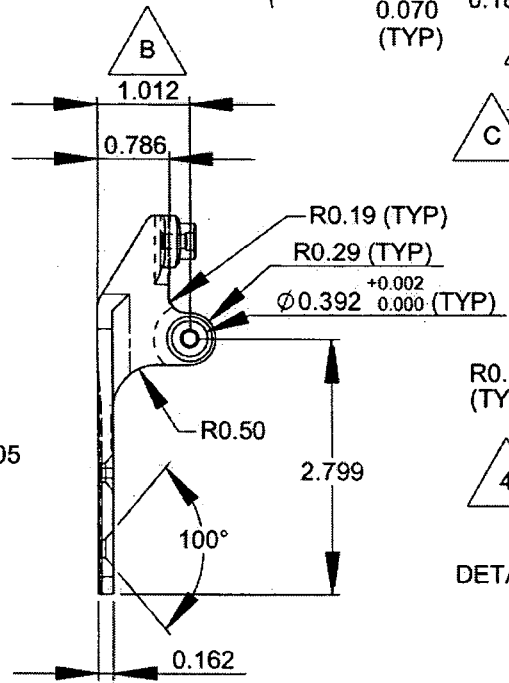
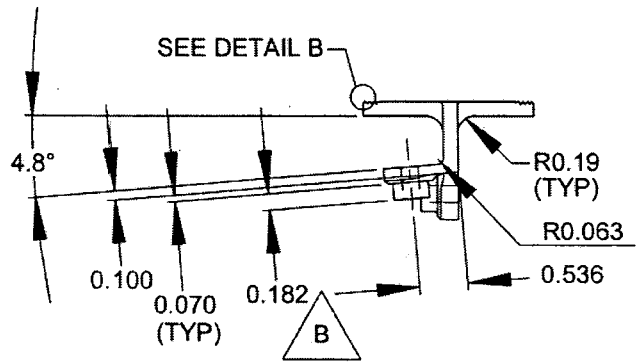
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DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2

RELEASED
04.03.01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

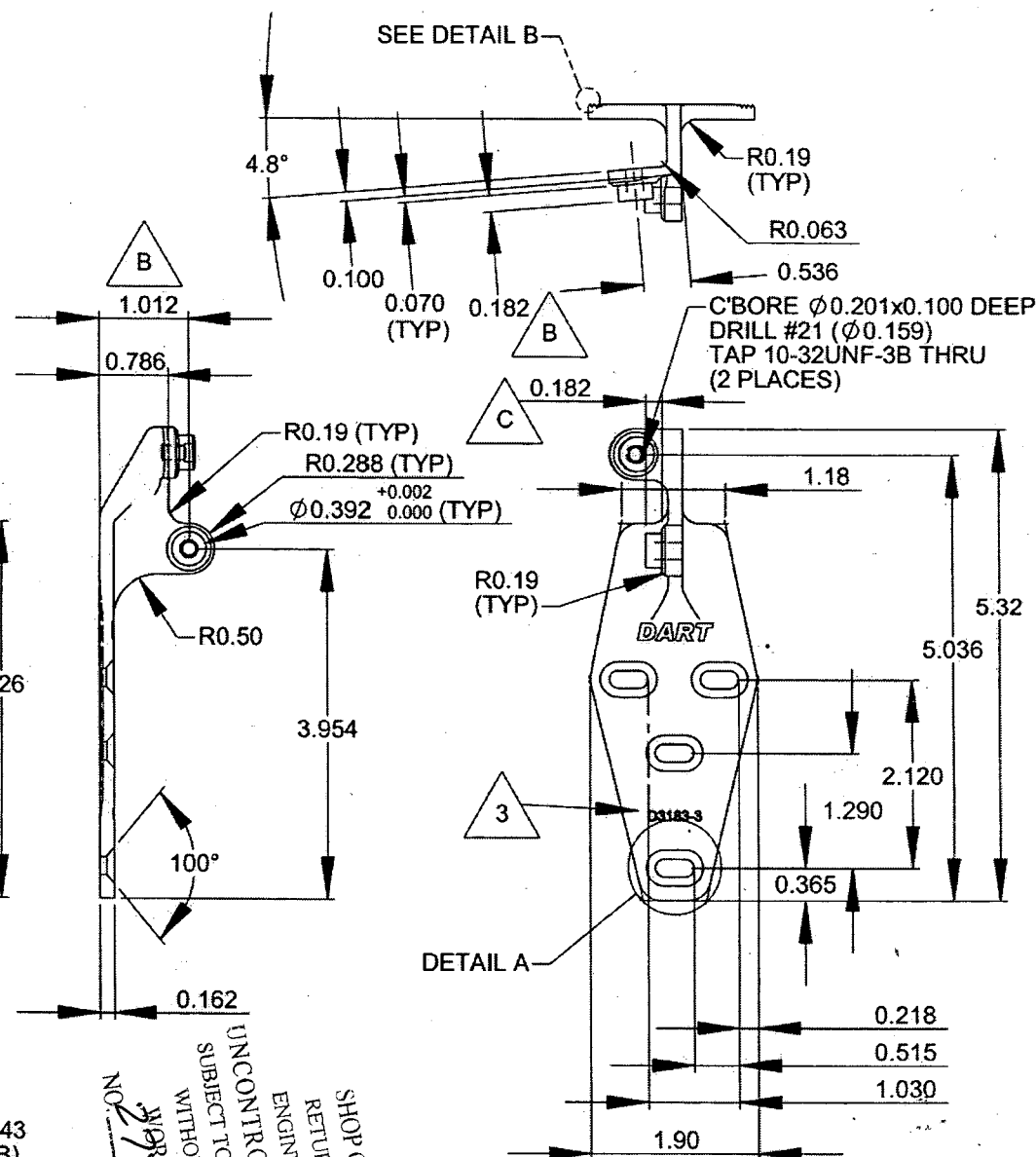
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DATE		D3183	SHEET 3 OF 4
04.02.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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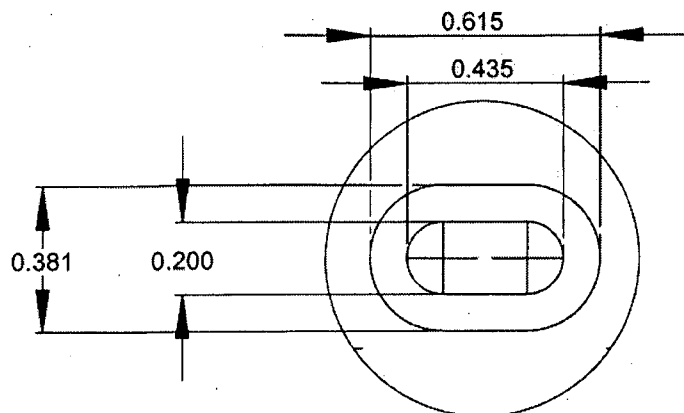
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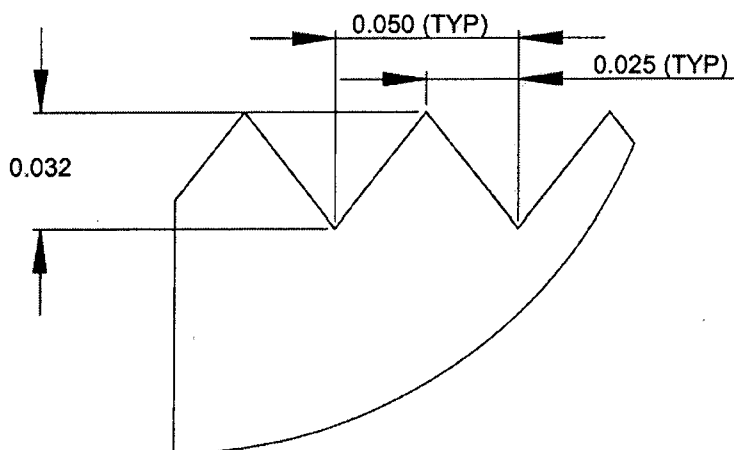


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DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

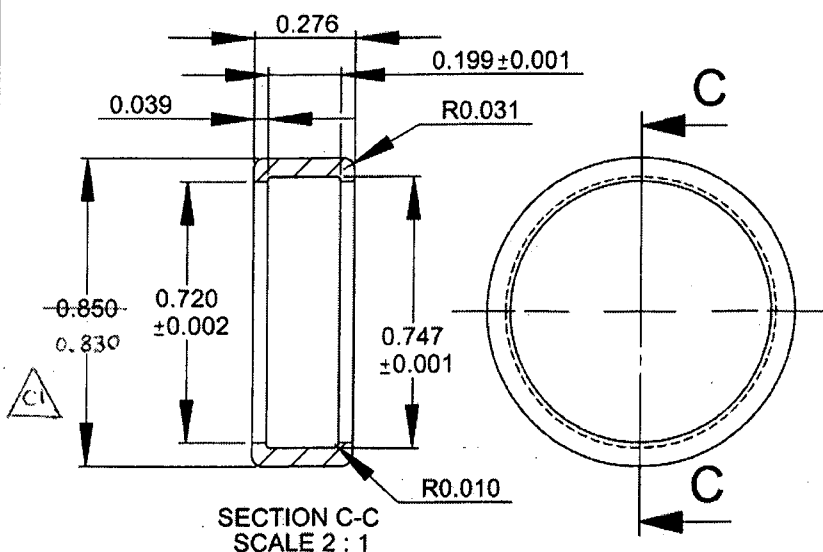


DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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